

TRISK

CUREMATE

CM4-12

CM3-12

**ASSEMBLY AND OPERATING
MANUAL**

WARNINGS

1. REMOVE PACKING PIECES FROM CASSETTE HEADS BEFORE USE.
2. **The CUREMATE MUST BE LOCATED WITHIN AN UNCLASSIFIED AREA.**
3. DO NOT MOVE THE UNIT AROUND USING THE MAINS CABLE.
4. DO NOT MOVE THIS UNIT DURING OPERATION AS THIS MAY LEAD TO PREMATURE EMITTER FAILURE.
5. THE FOLLOWING WIRING CONVENTIONS ARE USED:

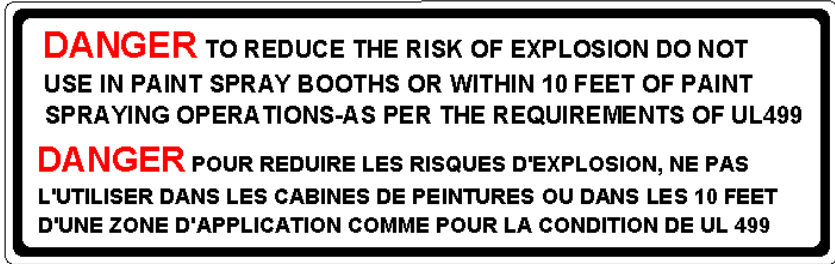
<u>CABLE</u>	<u>TYPE</u>
BLACK	L 1
WHITE	L 2
GREEN	GROUND

<u>CABLE</u>	<u>TYPE</u>
BLUE	L 1
BROWN	L 2
GREEN/YELLOW	GROUND

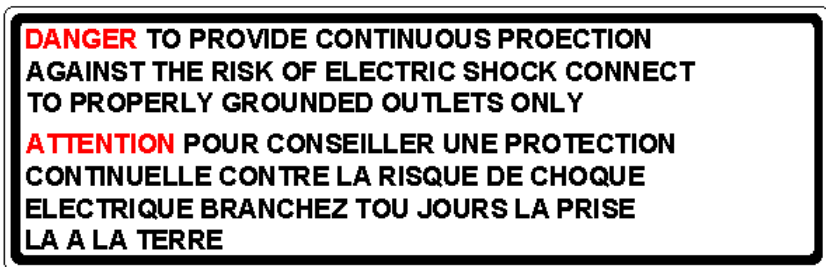
6. **Danger** Isolate mains supply before moving cover.



7. **Danger** to reduce risk of explosion , do not use in spray booths or within 10 feet of paint spraying operations –As per the requirements of UL 499.



8. **CAUTION** to provide continuous protection against risk of electric shock connect to properly grounded outlets only.



9. **Caution** hot surface do not touch



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1. INTRODUCTION

Congratulations on buying a TRISK branded product! Your CUREMATE unit is manufactured to the highest specifications in order to meet your needs. TRISK is the undisputed market leader in the manufacture of short-wave infrared paint curing equipment for the automotive refinishing industry. The company now exports to over 40 countries with a wide range of static and mobile infrared units. TRISK products are not only used in advanced bodyshops throughout the world but also by major car manufacturers including, Ford, Nissan, Rover, Land Rover, Seat and Toyota. Your product is designed to be energy efficient and versatile, while helping to produce the type of finish you would expect from a quality manufacturer. We are confident that TRISK will remain at the leading edge of developing infrared technology into the Next Millennium.

Please read through this operating manual before using the machine and afterwards store it in a safe place.

2. TECHNICAL SPECIFICATIONS

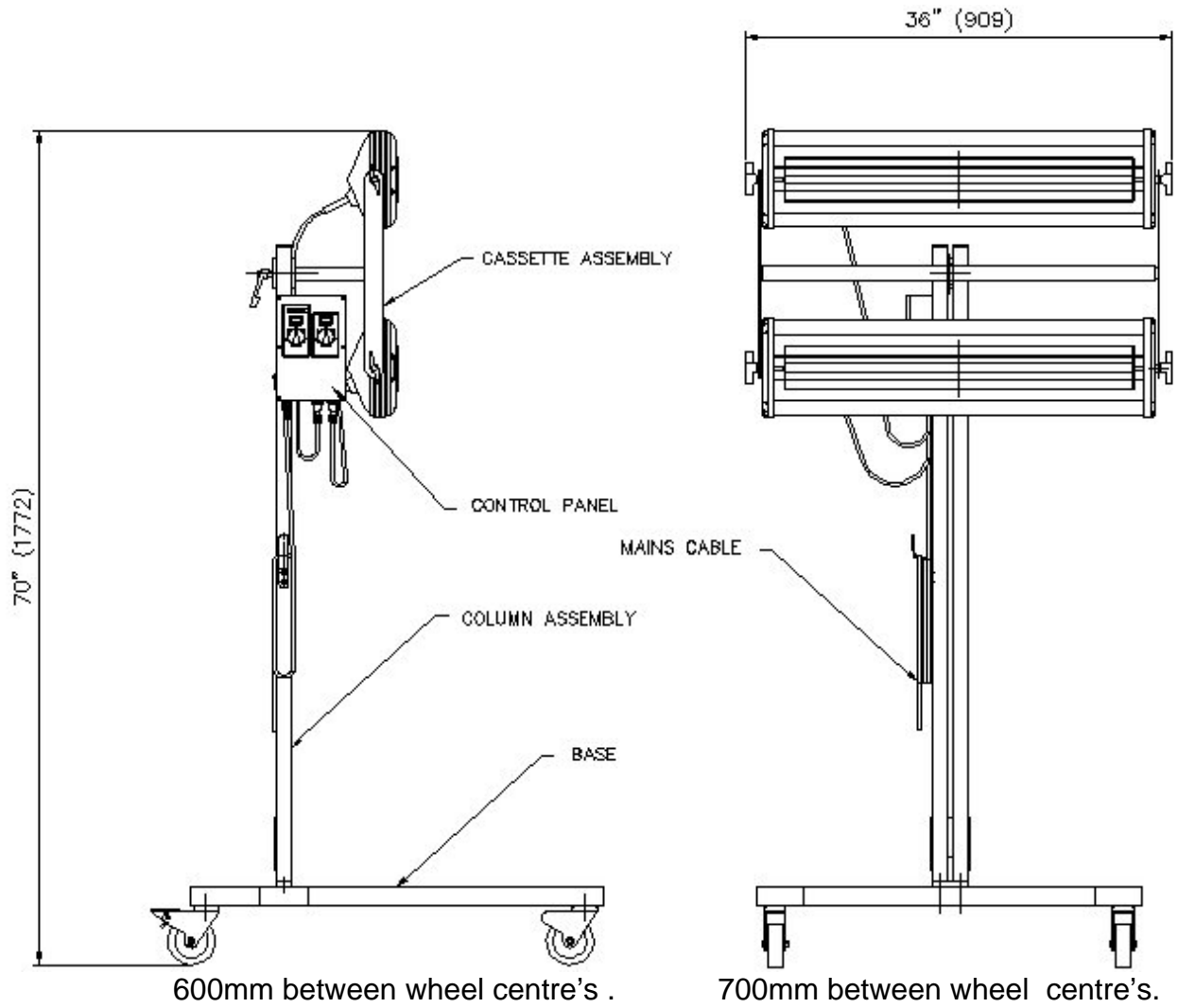
CUREMATE CM4

Rated Voltage:	220-240V 60Hz, Single Phase
Power Consumption: (Nominal)	1 emitter, half power: 560-750W 1 emitter, full power: 1310-1500W 2 emitters, half power: 1310-1500W 2 emitters, full power: 2620-3000W
Heating elements:	2 quartz, tungsten filament ruby sleeved infrared emitters
Areas of coverage: (Nominal)	39" x 31.5" (1000mm x 800mm)
Dimensions: (Nominal)	Width: 36" (820mm), Height: 70" (1780mm), Length: 38" (960mm).
Weight:	25kgs

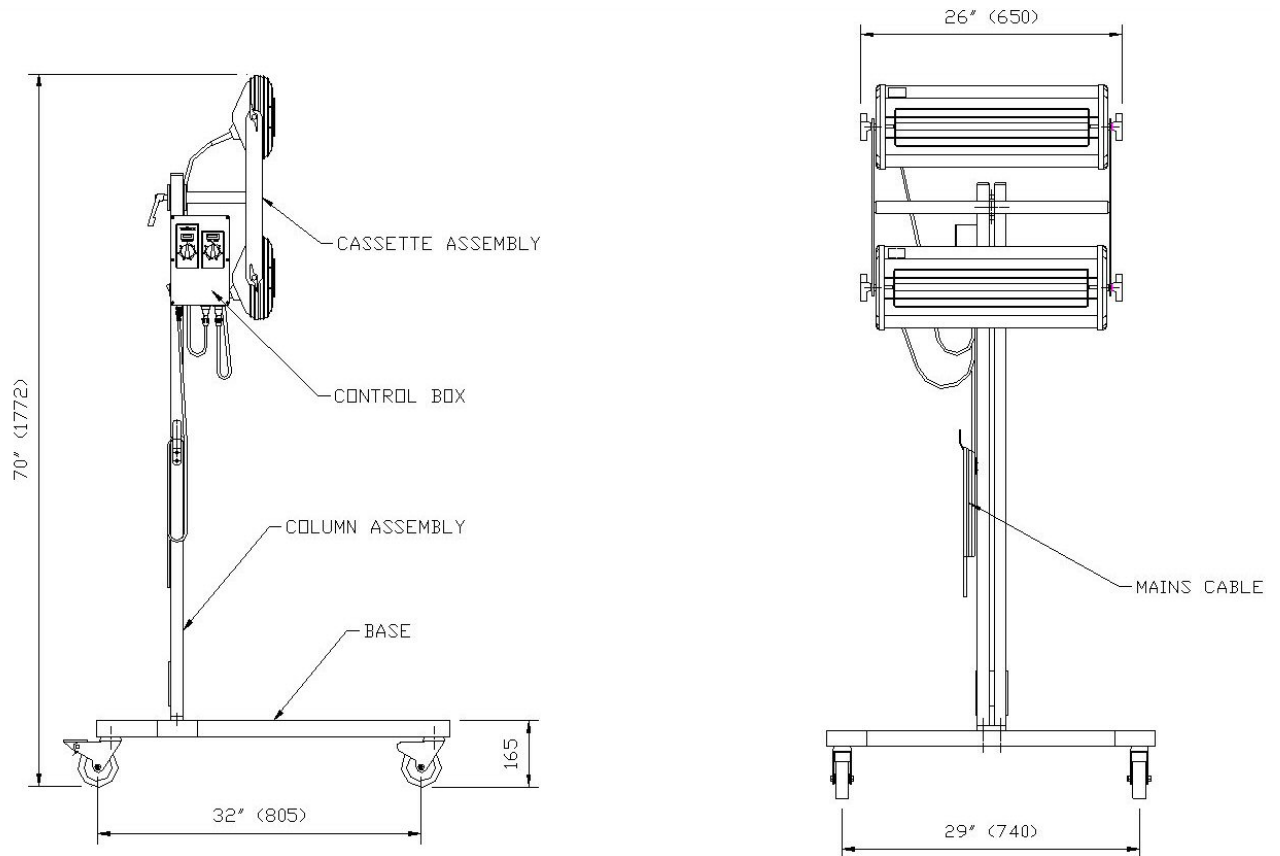
CUREMATE CM3

Rated Voltage:	220-240V 60Hz, Single Phase
Power Consumption: (Nominal)	1 emitter, half power: 373-500W 1 emitter, full power: 873-1000W 2 emitters, half power: 873-1000W 2 emitters, full power: 1747-2000W
Heating elements:	2 quartz, tungsten filament ruby sleeved infrared emitters
Areas of coverage: (Nominal)	24" x 31.5" (600mm x 800mm)
Dimensions: (Nominal)	Width: 32" (820mm), Height: 70" (1780mm), Length: 38" (960mm).
Weight:	25kgs

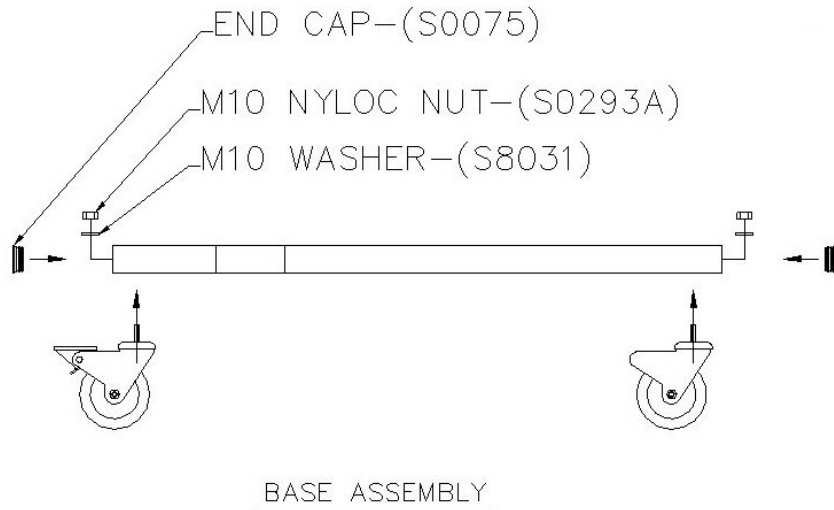
CM4 MACHINE LAYOUT



CM3 MACHINE LAYOUT

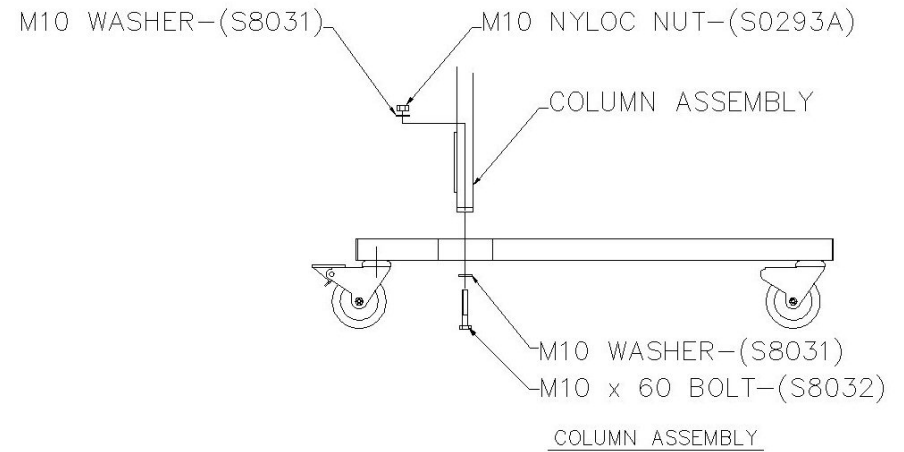


3. ASSEMBLY INSTRUCTIONS



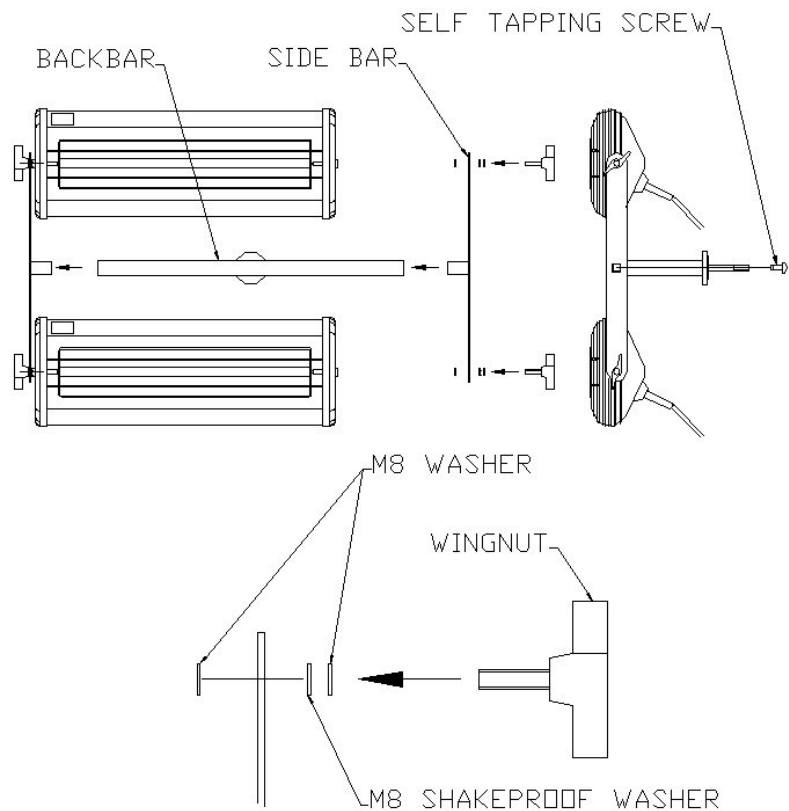
3.1 BASE ASSEMBLY

Fit wheels to the Base assembly using the locknuts and washers provided, then fit the plastic end caps. The braked wheels are fitted to the upright end of the base. Apply the brakes on the rear wheels before continuing to the next stage of the assembly.



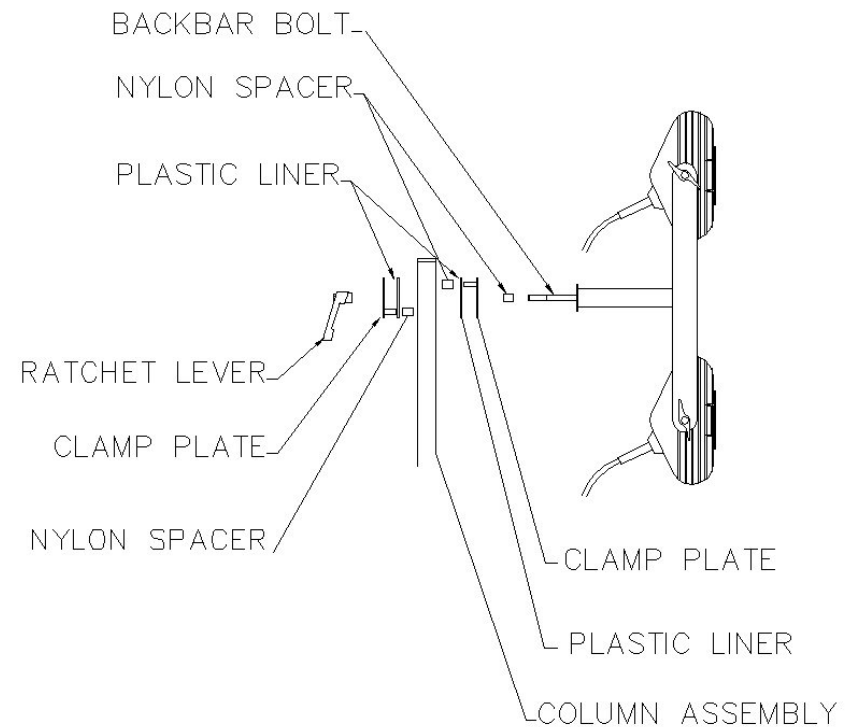
3.2 COLUMN ASSEMBLY

Insert the M10 X 65 bolts with washers into the two holes in the base assembly and fit the washers and locknuts, taking care not to over tighten the locknuts. Check the upright for rigidity with respect to the base and retighten the locknuts if required.



3.3 CASSETTE / BACKBAR ASSEMBLY

Remove wingnuts, washers and side bar from one side of cassette assembly. Insert backbar into remaining sidebar, align screw holes on back face. Insert self-tapping screws and tighten. Insert previously removed sidebar into backbar. Re-assemble wingnut and washer as shown. Align screw holes, insert self-tapping screw and tighten. Tighten wingnuts.



3.4 CASSETTE / BACKBAR TO COLUMN ASSEMBLY

Assemble plastic liners and nylon spacers onto clamp plates. Assemble one clamp plate assembly onto backbar bolt. Fit remaining nylon spacer onto backbar bolt. Pass backbar bolt with nylon spacer into upright. Assemble second clamp plate assembly onto backbar bolt as shown. Fit ratchet lever onto backbar bolt and tighten.

4. OPERATING INSTRUCTIONS

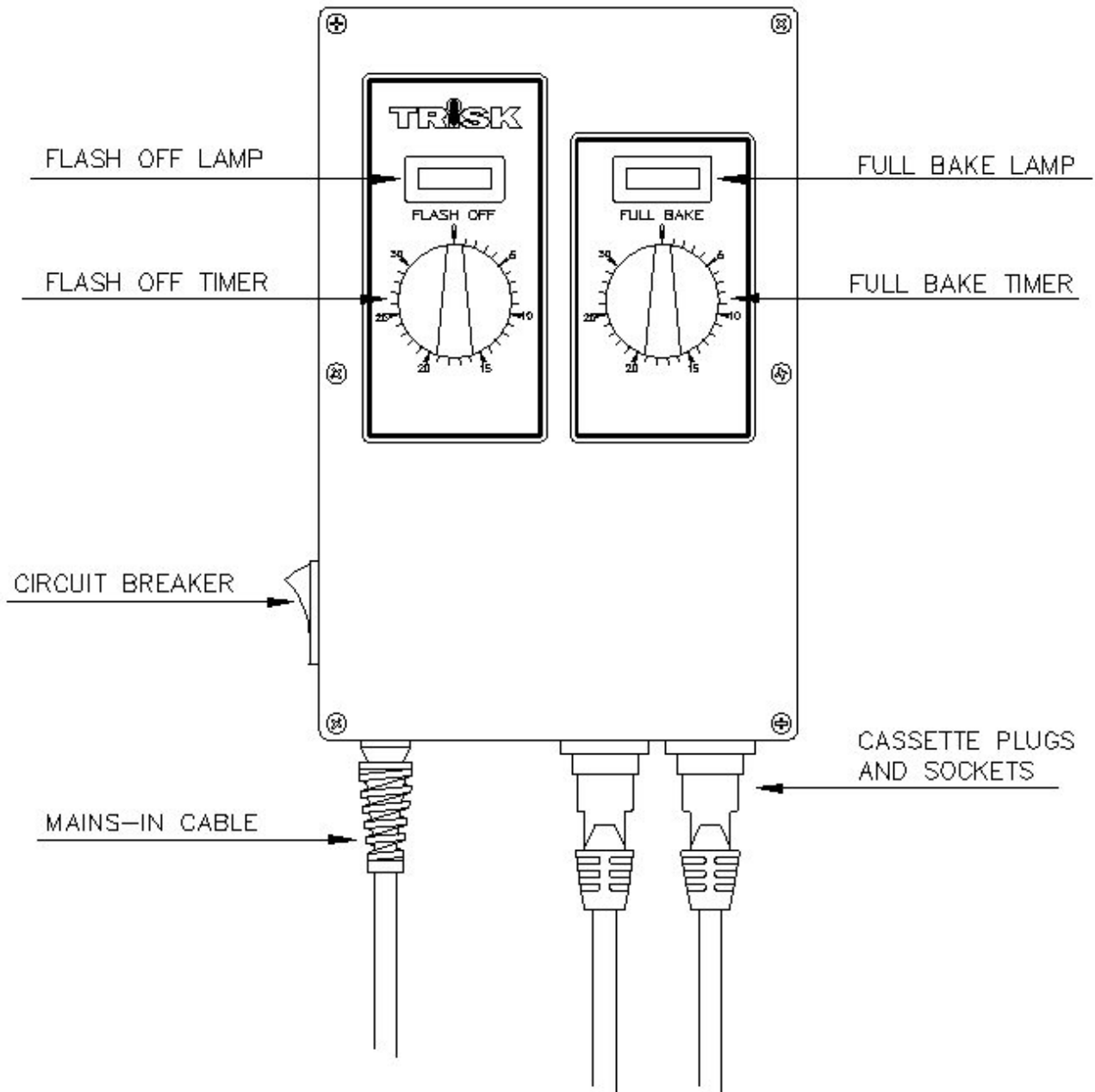
1. Ensure mains supply is disconnected before making any adjustments.
2. Set the Infra-Red Cassettes at a minimum distance of 500mm (20”) from the painted panel and where possible arrange the cassettes to follow the contours of the surface. To do this you will have to adjust the height and position of the cassettes.

- Height adjustment:
- a. Grasp the back bar grab handle and release the ratchet lever.
 - b. Move carriage to desired height
 - c. Retighten ratchet lever

- Individual cassettes:
- a. Rotation of each cassette is achieved by loosening the wing knobs at the end of each cassette. Rotation is limited to 30°

3. Lock the rear wheels of the unit to avoid accidental movement of the unit during operation.
4. Switch the unit on at the mains switch (See Section 4.1 Control Panel Layout).

4.1 CONTROL PANEL LAYOUT



- | | |
|-------------------------|--|
| FLASH OFF LAMP: | ILLUMINATES WHEN HALF POWER TIMER ENABLED. |
| FLASH OFF TIMER: | CONTROLS THE DURATION OF HALF POWER. |
| FULL BAKE LAMP: | ILLUMINATES WHEN FULL POWER SETTING ENABLED. |
| FULL BAKE TIMER: | CONTROLS THE DURATION OF FULL POWER SETTING. |
| CIRCUIT BREAKER: | OVER CURRENT / MAINS ISOLATOR. |

5. To prepare the unit for operation;
 - a. Set the timers to the recommended times. Timer duration is set by rotating the timer knobs clockwise until the desired times are reached.

NOTE. The FLASH OFF timer controls the duration of the half power output of the emitters. The FULL BAKE timer controls the duration of the full power output of the emitters. If both FLASH OFF and FULL BAKE timers are used, the FLASH OFF timer will run down first and upon switching off will engage the FULL BAKE timer automatically.

5. CURE TIMES

The tables below give a guide for different finishes:

<i>PAIN T TYPE</i>	<i>FLASH OFF*</i>	<i>FULL BAKE</i>
Filler/Stopper	--	4 - 6 minutes
Primer	--	6 - 8 minutes
Hi-Build	--	10 minutes
Solid-Color	--	11 minutes
Clear Coat	--	12 minutes
Waterborne Primer	--	8 –10 minutes
Waterborne Basecoat	--	5 minutes

*All the above times are based upon FULL BAKE cycles although some coatings require a FLASH OFF / half power setting. This is normally used on coatings with a high film build and also on dark colours. This setting is used for approximately 5 minutes before Full Bake.

For detailed curing information, contact your local TRISK distributor for a data sheet. Paints from Akzo Coatings, B.A.S.F., Du Pont, De Beer, Herberts, ICI, Maxmeyer, P.P.G., Spies Hecker and Sherwin Williams are included in this information.

6. PAINT CURE FAULT FINDING

<i>PROBLEM</i>	<i>POSSIBLE CAUSE</i>	<i>POSSIBLE SOLUTION</i>
SOLVENT POPPING	Unit too close to panel Insufficient flash off time Paint system has a fast Thinner	Move unit further away Increase flash off time Use a standard or slow Thinner
UNDER CURE OR SOFTNESS OF THE PAINT FILM	Unit too far away Insufficient bake time Excessive film weight	Move unit closer Increase full bake time Apply lighter coats
SOFTNESS ON EDGES OF REPAIR	Repair too large for I.R. unit	Split area into two Move unit for 2nd application If flash off is used, it will not be necessary on 2nd Application
DIFFICULTY IN POLISHING OUT DIRT NIBS	Too long on bake cycle Unit too close to panel	Reduce cure time Move unit further away
UNEVEN CURE	I.R. Cassettes not shaped to contours of repair	Adjust I.R. Cassettes for even heat distribution

6. GENERAL MAINTENANCE

The Curemate unit with regular use will require general maintenance from time to time;

REFLECTOR CLEANING

1. Disconnect unit from mains power supply.
2. Allow cassette to cool down to room temperature if necessary.
3. Remove the contamination on the reflector using a soft cloth with a solvent such as IPA or Methylated Spirits.
4. Allow 15 minutes for the solvent to dissipate before switching on.

INFRA-RED EMITTER REPLACEMENT

1. Check that replacement has correct voltage and wattage ratings. Check old emitter end caps if in doubt.
2. Ensure unit is disconnected from mains power supply.
3. Remove wire grille from front of cassette.
4. Remove self-tapping screws, which hold side reflectors into cassette. A small screwdriver will be necessary to lift the side reflector from the cassette.
5. When the side reflector is removed, take note of the cable positions before removing old emitter.
6. The in-line connectors can be separated by hand, but a better solution is to use two pairs of pliers. One to hold each connector when separating wires.
7. Fit new Infrared Emitter to sockets in cassette. To avoid touching the ruby sleeve with bare hands use tissue paper when handling.
8. Reconnect Infrared Emitters to cassette wiring, taking care to replace the wires in the original positions.
9. Fit side reflectors and then clean ruby sleeve and reflector with IPA or Methylated Spirits.
10. Refit grille.
11. Allow 15 minutes for the solvent to dissipate before switching on.

7. IN THE EVENT OF A FAILURE

Please note the following details before phoning your TRISK distributor;

1. SERIAL NUMBER*
2. MODEL NUMBER
3. DATE OF PURCHASE
4. EXPLANATION OF PROBLEM
5. LOCATION OF DAMAGED PARTS
6. HOW THE DAMAGE WAS CAUSED

*To be found on the control panel

IF ANY PROBLEMS ARE ENCOUNTERED WITH THE ASSEMBLY OR ANY OTHER ASPECT OF THE UNITS PERFORMANCE PLEASE CONTACT THE TRISK SERVICE DEPARTMENT.



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